

Work Order ID 105618

Thursday, August 08, 2013 2:36:12 PM

105618

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Item ID: D3912-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Eyebolt

Start Date: 8/8/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 8/22/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *13-08-08*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3912

B

100

0.00

100

Doosan.

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871 AND DWG

Prog Rev: *U/A*

Dwg Rev: *13*

Deburr as required

SA

13-10-03

40 *φ*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SA *13-10-03*

40 *φ*

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Accept

N900040100

Setup Start

NS1

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NS2

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Required Date: 8/22/2013 Req'd Qty: 40.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

on 13/10/09

120

QC

Memo

0.00

40

Quality Control

130

Identify as per dwg & Stock Location: *ST144*

0.00

130

Packaging

Memo

0.00

40

Packaging

DAS
33
9-89

13-10-09

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

AD/Rm 13/10/10

mf

13-10-10

Picklist Print

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Work Order ID: 105618

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Parent Item: D3912-1

D3912-1

Parent Item Name: Eyebolt

Start Date: 8/8/2013

Required Date: 8/22/2013

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased	No			100	f	13.2660	0.25	10.52632			

M303R2 000
303 ROUND BAR 2"

**

13-10-03

Location	Loc Qty	Loc Code
MAT029	13.266	
116656	2.854	
116700	0.708	
121846	2.972	
122682	6.732	

3'
4'

126805

10.5 LT

3.5

DART AEROSPACE LTD		Work Order: 105618
Description: Eyebolt		Part Number: D3912-1
Inspection Dwg: D3912	Rev: B	Page 1 of 1

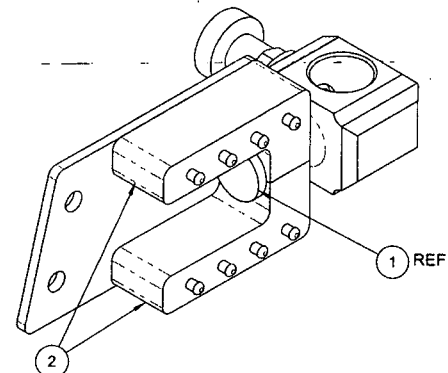
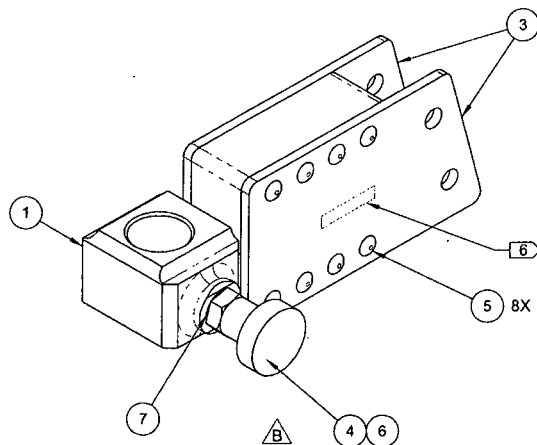
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.127	/			
Ø0.700	+/-0.010	.700	/			
Ø0.500	+/-0.010	.501	/			
0.90	+/-0.030	.903	/			
0.13 x 45°	+/-0.030 x 0.5°	.13 x 45°	/			
0.22	+/-0.030	.221	/			
0.75	+/-0.030	.749	/			
0.970	+/-0.010	.971	/			
1.72	+/-0.030	1.721	/			
1.20	+/-0.030	1.196	/			
0.625	+/-0.010	.623	/			
2.23	+/-0.030	2.225	/			
R0.13	+/-0.030	R.125	/			
R0.015	+/-0.010	R.015	/			
0.625	+/-0.010	.625	/			
Ø0.650	+/-0.010	.652	/			
1.100	+/-0.010	1.102	/			
0.44	+/-0.030	.44	/			
R0.13	+/-0.030	R.125	/			
1.00	+/-0.030	1.005	/			
0.25	+/-0.030	.25	/			
0.88	+/-0.030	.878	/			
0.11	+/-0.030	.110	/			
Ø0.719	+0.010/-0.000	.723	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 13-10-03	Date: 13/10/09	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ <i>[Signature]</i>	<i>[Signature]</i>

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

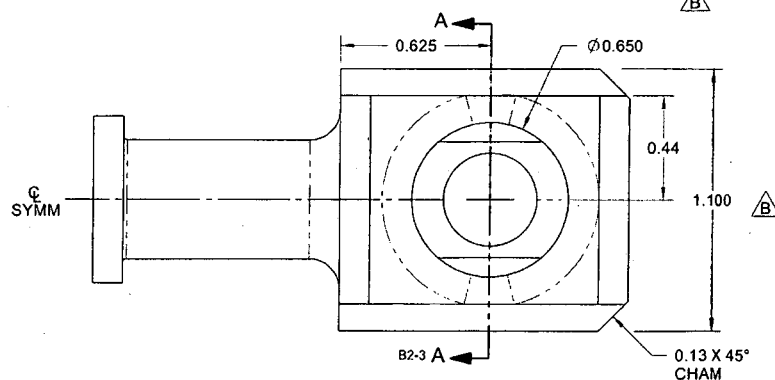
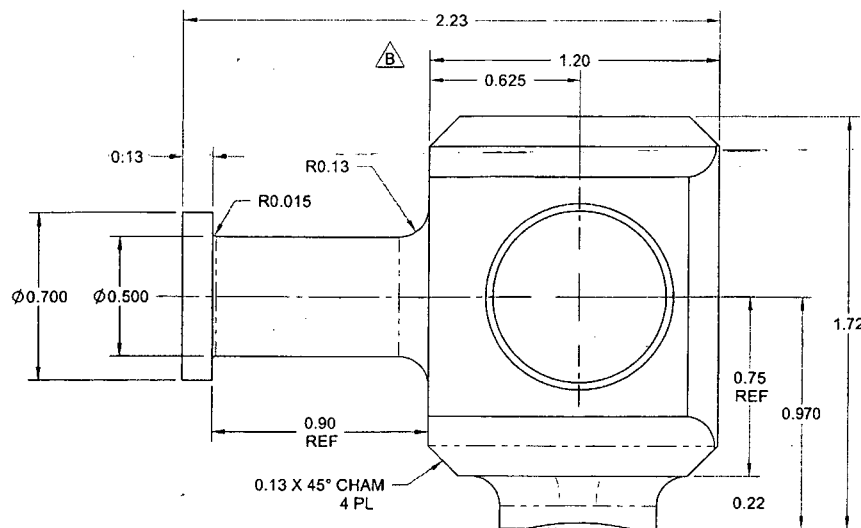
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

105618 MJS
13-08-08

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0863R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1/5		
DRAWN	1/1		
CHECKED	1/1		
MFG. APPR.	1/1		
APPROVED	1/1		
DE APPR.	1/1		
DATE	10.06.28		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3912 TITLE EYEBOLT RECEIVER ASSY REV. B SHEET 1 OF 3 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

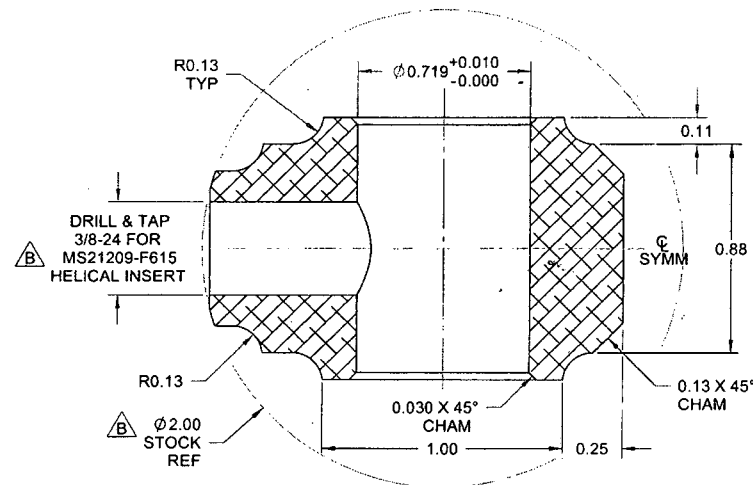
105618



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3912	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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